

Split

Work Order ID 78814-2

78814

Page 1

Item ID: D3999-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Baffle Assembly, Fwd

Start Date: 16/01/2012 Start Qty: 5.00

5

Required Date: 30/01/2012 Req'd Qty: 5.00

5

Cust Item ID:

Reference:

Customer:

Approvals: Process Plan: M C D

Date: 12/01/16

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D3999

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: 1

Prog Rev: 1

2-Deburr if necessary

RB 2-2-2

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

RB 2-2-2

8

Work Order ID 78814

January-16-12 11:21:14 AM

78814

Page 2

Item ID: D3999-043

Revision ID:

Item Name: Baffle Assembly, Fwd

Start Date: 16/01/2012 Start Qty: 5.00

Required Date: 30/01/2012 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

Bend D3999-3 as per Dwg

180

0.00

180

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg

EP 12/02/03

Work Order ID 78814

January-16-12 11:21:14 AM

78814

Page 3

Item ID: D3999-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Baffle Assembly, Fwd

Start Date: 16/01/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: WA

0.00

200

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

S 12/02/03

(H)

12-02-07 (1)

MLJ 12/02/07

ME 12-02-07

Picklist Print

January-16-12 11:21:18 AM

Page 1

Work Order ID: 78814

78814

Parent Item: D3999-043

D3999-043

Parent Item Name: Baffle Assembly, Fwd

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP rev A 09.12.16 new issue Prelim EC verified by:DD IPP rev B 10.05.10 cen 10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

354.0696

2.66

14

16

M6061T6S 063

6061-T6 .063 Sheet

**

B12-2-2

Location

Loc Qty

Loc Code

MAT021

354.0695684

113608

0

116308

11.9555684

117285

75.414

119331

49.2

119802

25.5

120218

192

D3999-5

Manufactured

No

180

Each

10.0000

2

10

D3999-5

Angle

**

120218
EP 12/02/03

Location

Loc Qty

Loc Code

ST104

10

71295

1

72654

9

MS20470AD4-4

Purchased

No

180

Each

3,392.000

12

60

MS20470AD4-4

Rivet, Universal Head

**

2
EP 12/02/03

Location

Loc Qty

Loc Code

ST319

3392

116188

136

116391

66

118614

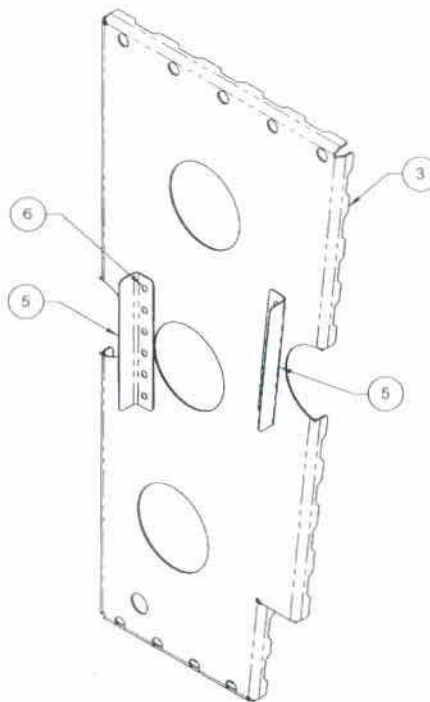
1190

119109

2000

12

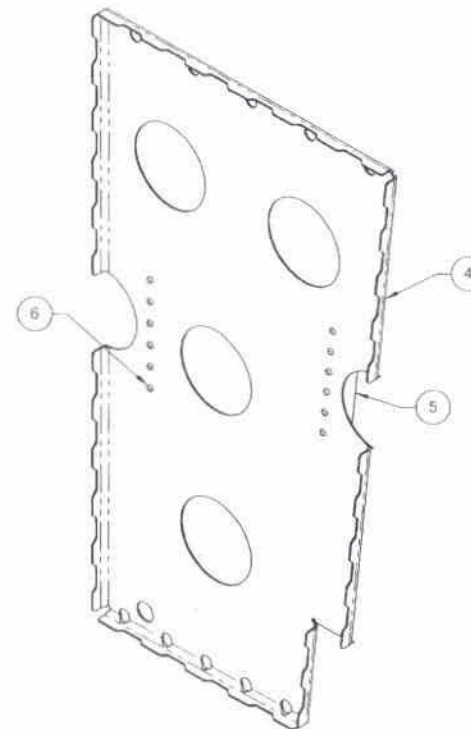
ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X		D3999-041	BAFFLE ASSEMBLY, AFT	JCA-M47-1-02
2		X	D3999-043	BAFFLE ASSEMBLY, FWD	JCA-M47-1-03
3	1		D3999-1	BAFFLE	
4		1	D3999-3	BAFFLE	
5	2	2	D3999-5	ANGLE	
6	12	12	MS20470AD4	RIVET	



D3999-041 BAFFLE ASSEMBLY, AFT

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3999-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT (-041): 1.51 lbs
- 8) WEIGHT (-043): 1.84 lbs



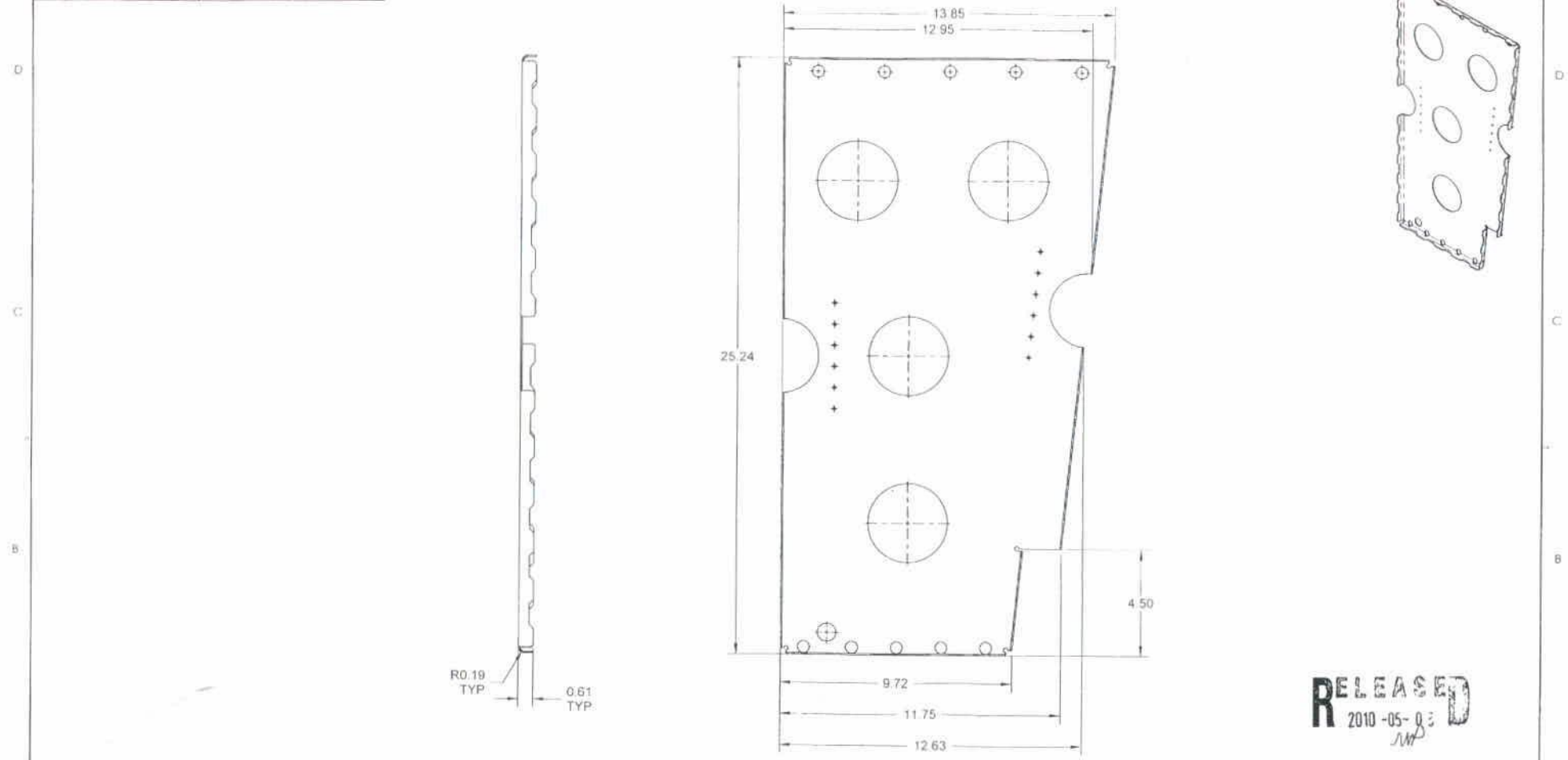
D3999-043 BAFFLE ASSEMBLY, FWD

RELEASED
2010-05-05

A. NEW ISSUE		BY	10 02 05
REV.	DESCRIPTION	DATE	
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO D3999 TITLE BAFFLE COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR IN CONNECTION WITH ANY OTHER PERSONS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	REV. A	
DRAWN		SHEET 1 OF 12	
CHECKED		SCALE	
MFG. APPR		NTS	
APPROVED			
DE APPR			
DATE	10.02.05		

78814

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-3	REF JCA-M47-1-03



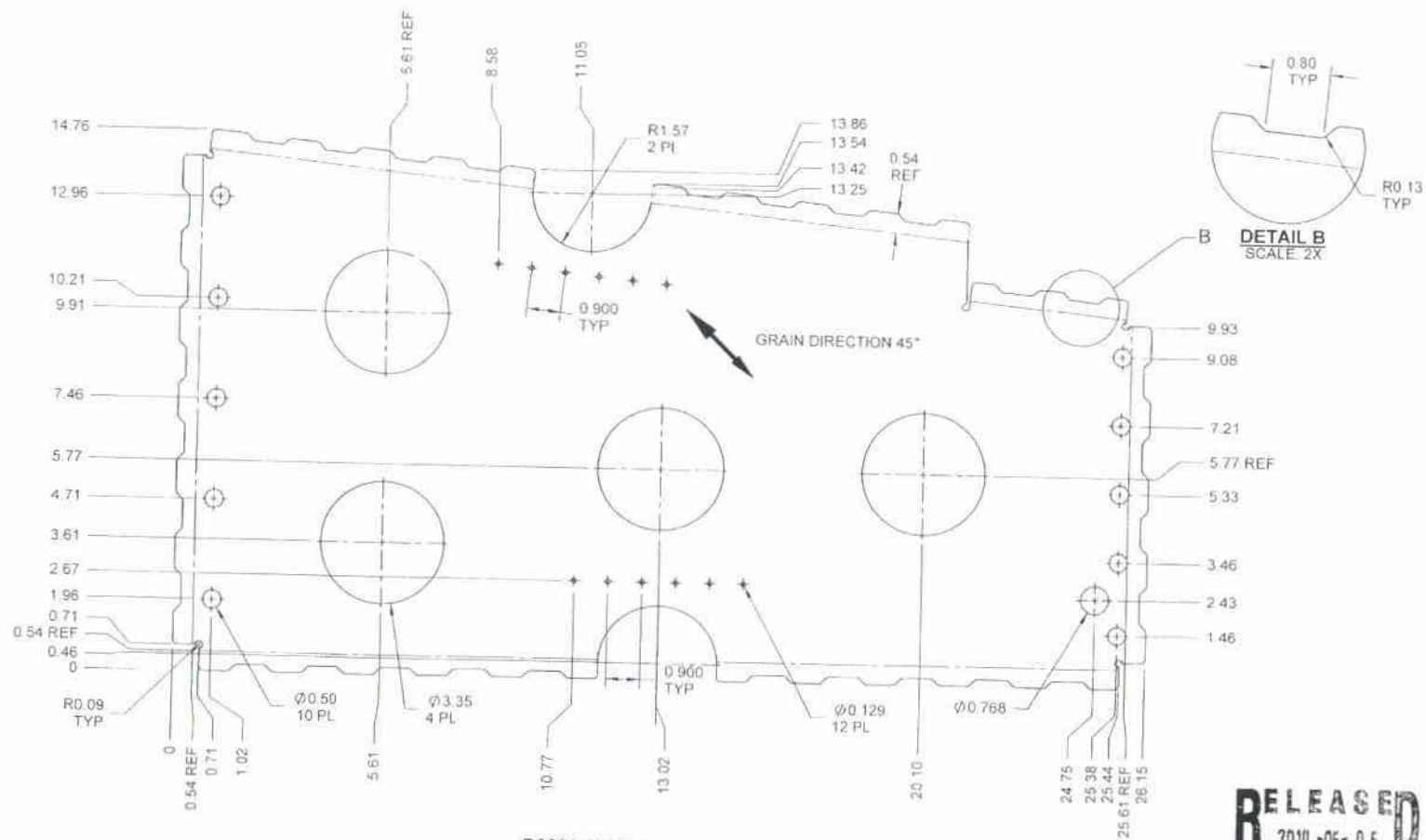
D3999-3 BAFFLE

- NOTES**
- 1) MATERIAL: MADE FROM D3999-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.77 lbs

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 2010-05-03
MS

70514



D3999-3F FLAT PATTERN

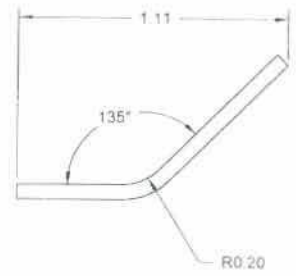
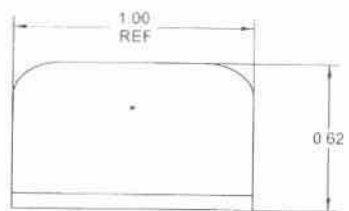
RELEASED
2010-05-05
MP

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.77 lbs

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73814

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-11	JCA-M47-1-19



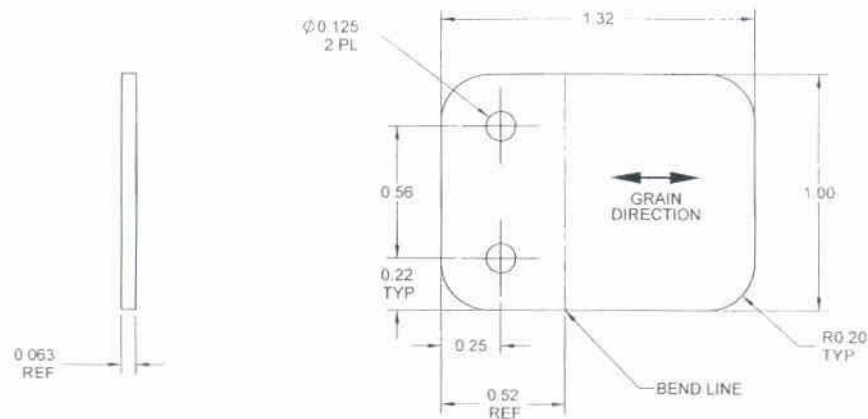
D3999-11 EARTH TAB

RELEASED
2010-05-05
MD

- NOTES:
- 1) MATERIAL: MADE FROM D3999-11F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.01 lbs

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10014



D3999-11F FLAT PATTERN

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2010-05-05
MD

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.01 lbs

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DART AEROSPACE LTD		Work Order:	75514
Description: Baffle		Part Number:	D3999-3
Inspection Dwg: D3999	Rev: A	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130	✓		U 1307	
Ø0.50	+0.006/-0.001	0.504	✓		✓	
Ø0.768	+0.010/-0.001	0.773	✓		✓	
Ø3.35	+0.012/-0.001	3.356	✓		✓	
0.71	+/-0.030	0.71	✗		✓	
1.02 1.02	+/-0.030	1.018	✓		✓	
5.61	+/-0.030	5.61	✓		✓	
10.77	+/-0.030	10.765	✓		T 31	
13.02	+/-0.010	13.02	✓		T	
20.10	+/-0.030	20.10	✓		T	
24.75	+/-0.030	24.75	✓		T	
25.38	+/-0.030	25.38	✓		T	
25.44	+/-0.030	25.44	✓		T	
26.15	+/-0.030	26.15	✓		T	
1.46 1.46	+/-0.030	1.455	✓		✓	
2.43	+/-0.030	2.439	✓		✓	
3.46	+/-0.030	3.464	✓		✓	
5.33	+/-0.030	5.333	✓		✓	
5.77	+/-0.030	5.77	✓		✓	
7.21	+/-0.030	7.21	✓		✓	
9.08	+/-0.030	9.08	✓		✓	
9.93	+/-0.030	9.93	✓		✓	
0.80	+/-0.030	0.807	✓		✓	
0.71	+/-0.030	0.714	✓		✓	
1.96	+/-0.030	1.964	✓		✓	
2.67	+/-0.030	2.681	✓		✓	
3.61	+/-0.030	3.619	✓		✓	
4.71	+/-0.030	4.71	✓		✓	
5.77	+/-0.030	5.77	✓		✓	
7.46	+/-0.030	7.46	✓		✓	
9.91	+/-0.030	9.91	✓		T	
10.21	+/-0.030	10.21	✓		T	
12.96 12.96	+/-0.030	12.96	✓		T	
14.76	+/-0.030	14.76	✓		T	

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	10.08.03	New Issue P/O D3999-043	KJ	M